	Work	Order	ID	54798
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December 22, 2009 1:22:42 PM

Quality Control



Page 1

Item ID: D3763-6 Accept Setup Start **Revision ID:** Stop **Item Name:** Tube Start Qty: 10.00 **Start Date:** 12/28/09 **Cust Item ID:** Required Date: 1/04/10 Req'd Qty: 10.00 **Customer:** Reference: Run Start Process Plan: C Date: 09/12/23 Tooling: Approvals: Date: Stop QC: Date:____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Reject Draw Accept Plan Reject Insp. Work Center ID **Description** Qty Qty **Run Hours** Number Rev. Code Number Stamp Draw Nbr **Revision Nbr** D3763 Rev B 100 0.00 DOOSAN LATHE Doosan Doosan Lathe per dwg D3763 0.00 Sh 09/12/28 110 QC2- Inspect parts off machine FAI/FAIB 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 28 09/12/28 QC 0.00 Memo

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** DATE STEP **PROCEDURE CHANGE** Ву

DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Ye	s No	DQA:	Date: _	
	Re	esolution:	Disposition	on:	QA: N/C	Closed	d:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NO	CR)			
D.47F	0.755	Description of NC		Corrective Action Section		\	/erification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da	า &	Section C	Chief Eng	QC Inspector

NCH:) — (.)				
		Description of NC		Corrective Action Section B		Verification	Annuaral	Ammental	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

Work Order ID 54798

December 22, 2009 1:22:42 PM



Page 2

Item ID:

D3763-6

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Required Date: 1/04/10

Tube

QC:

12/28/09

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:_____

Tooling:

Date: Date: Run

Start Stop

Stop



Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

SPC (Y/N):

Set Up/

Run Hours

0.00

Draw Number

Draw Rev.

Plan Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

140

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/06 of

Dart Aerospace Ltd

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W/O:		100000000000000000000000000000000000000	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
1			takudi. T						
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A :	Date:	
	R	esolution:	Disposition	on:	_ QA: N/C CI	osed:	•	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	l)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign 8		cation	Approval Chief Eng	Approval QC Inspector
 		Collony	Chief Eng	Chief Eng	Date			Januar Eving	
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NOTE: Date & initial all entries

Picklist Print

December 22, 2009 1:22:41 PM

Work Order ID: 54798

Parent Item:

Comments:

D3763-6

Parent Item Name: Tube



Start Date: 12/28/09

Required Date: 1/04/10

Page 1

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			100	f	22.3671	2.2979			

6061-T6 Round Bar 1.250

Warehouse	Loc Oty	Loc Code	
Location		ļ	
Main Warehouse			
MAT	22.3671		
108876	9.6		
109733	7.04		
111321	3.3571		
18295	2.37		
113457			2-298

JL 09/12/28

Dart Aerospace Ltd

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W/O:	1		M	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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:									
Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposit	ion:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	CTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD •	Work Order:	<u> 54798</u>
Description: Tube	Part Number:	D3763-6
Inspection Dwg: D3763 Rev: B		Page 1 of 1

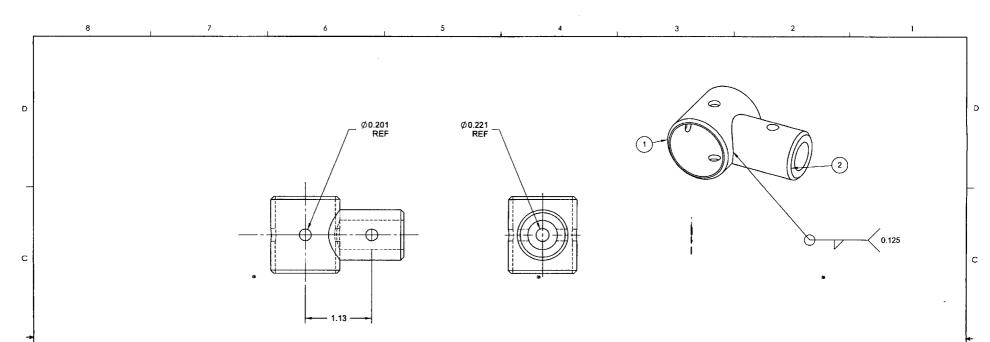
FIRST ARTICLE INSPECTION CHECKLIST

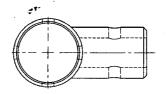
		ARTICLE IN				
	X	First Artic	:le	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.62	+/-0.030					
0.655	+/-0.010					
Ø0.221	+0.005/-0.001					
0.655	+/-0.010					
0.05 x 45°	+/-0.030 x +/-0.5°	5				
10°	+/-0.5°			. \		
90°	+/-0.5°		10			
Ø1.010	+0.010/-0.000		113	7		
Ø1.16	+/-0.030					
Ø0.323	+0.006/-0.001	12 4	D			
Measured by:	9/2/28	Audited by:	SP. 09/12/2	d	Prototype Ap	pproval: N/A Date: N/A
Rev Date A 08.09.04	Change New Issue		<i>J</i>		Revise KJ/DD	Approved

DART AERO	SPACE LTD			,	Work Order:	34371
Description: Tu	îbe				Part Number:	D3763-6
Inspection Dwg	j: D3763 Rev: B	3				Page 1 of 1
	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST	
-	X	First Artic	le	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.62	+/-0.030	2.619				
0.655	+/-0.010	-654				
Ø0.221	+0.005/-0.001	.222				
0.655	+/-0.010	.654				
0.05 x 45°	+/-0.030 x +/-0.5°	05X45°	V,			
10°	+/-0.5°	100	/			
90°	+/-0.5°	900	/			
Ø1.010	+0.010/-0.000	1.012				
Ø1.16	+/-0.030	1.160				

2.62	+/-0.030	2.619					
0.655	+/-0.010	-654	V				
Ø0.221	+0.005/-0.001	.222					
0.655	+/-0.010	.654_		 			
0.05 x 45°	+/-0.030 x +/-0.5°	-05X45°	<u>/</u>				
10°	+/-0.5°	100	/				
90°	+/-0.5°	900					
Ø1.010	+0.010/-0.000	1.012					
Ø1.16	+/-0.030	1.160					
Ø0.323	+0.006/-0.001	324					1 gen
			Year				
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		The state of the s					
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	:						
Measured by:	<u>\</u>	Audited by:	18	Proto	type A _l	pproval:	N/A
Date:	09/12/28	Date:	07/12/4			Date:	N/A
Rev Date	Change		/-/		Revis	ed by	Approved
IVEA Date	10			 	N NDE	-21	1/X

Date: 09/12/28 Date: 02/12	Date: N	/A
Rev Date Change	Revised by 1.A ARR	roved
A 08.09.04 New Issue	KJ/DD 🛠	7





1 D3763-3 TUBE 1 2 D3763-1 FITTING 1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
	1	D3763-3		1
	2		FITTING	1

D3763-041 END FITTING ASSY

08.06.23

08.06.04

DATE

REV. B

SCALE

SHEET 1 OF 9

HS

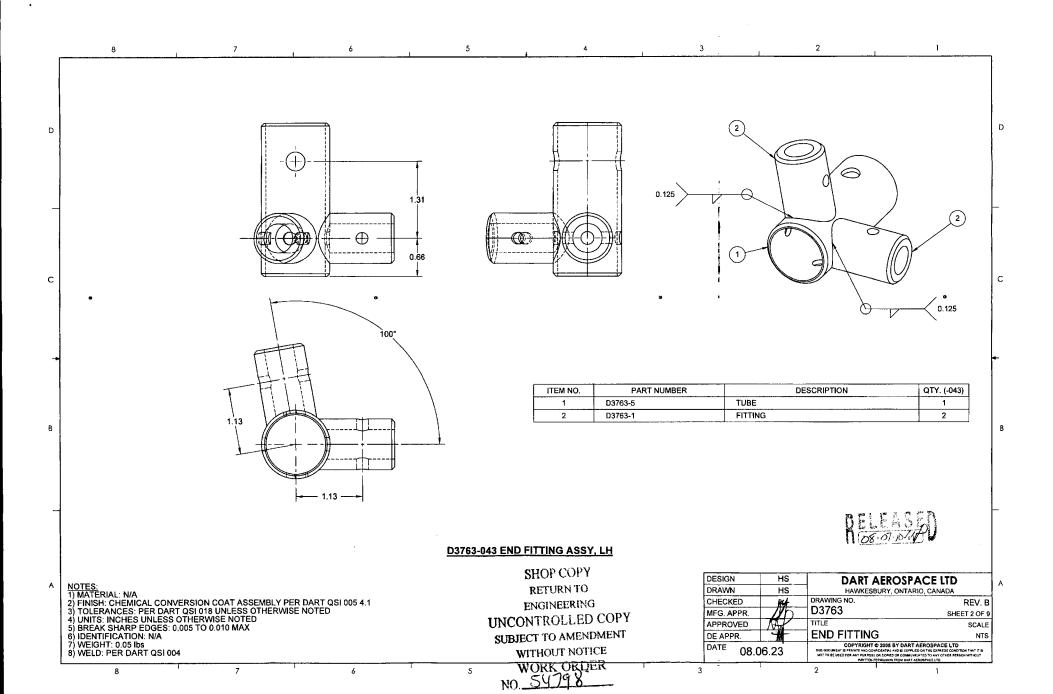
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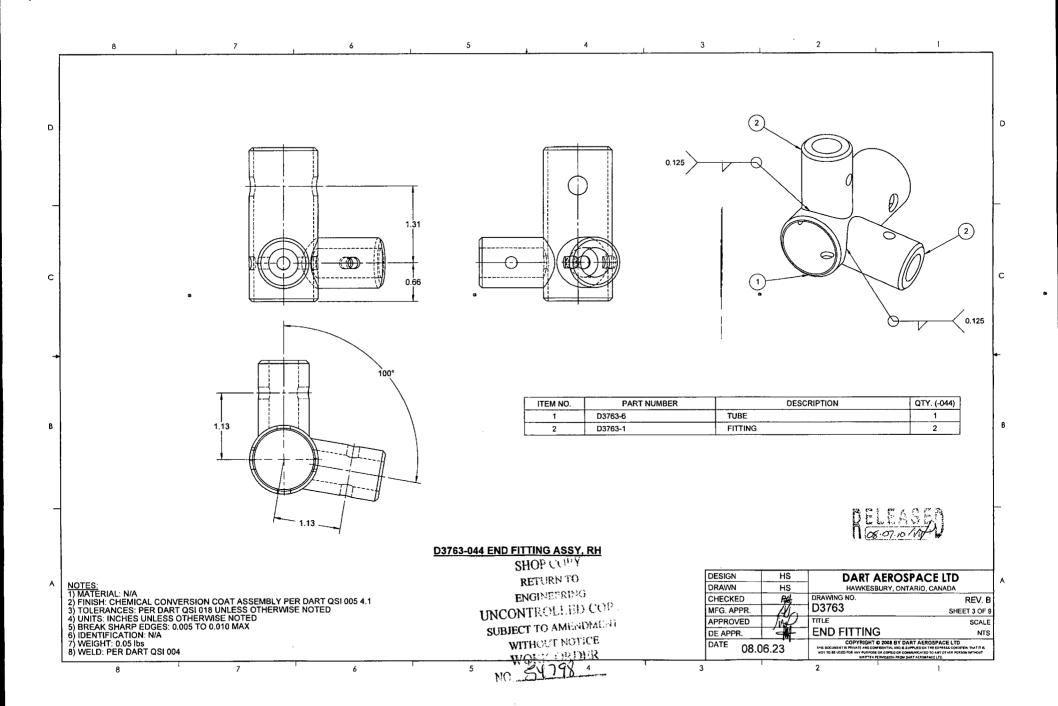
BY

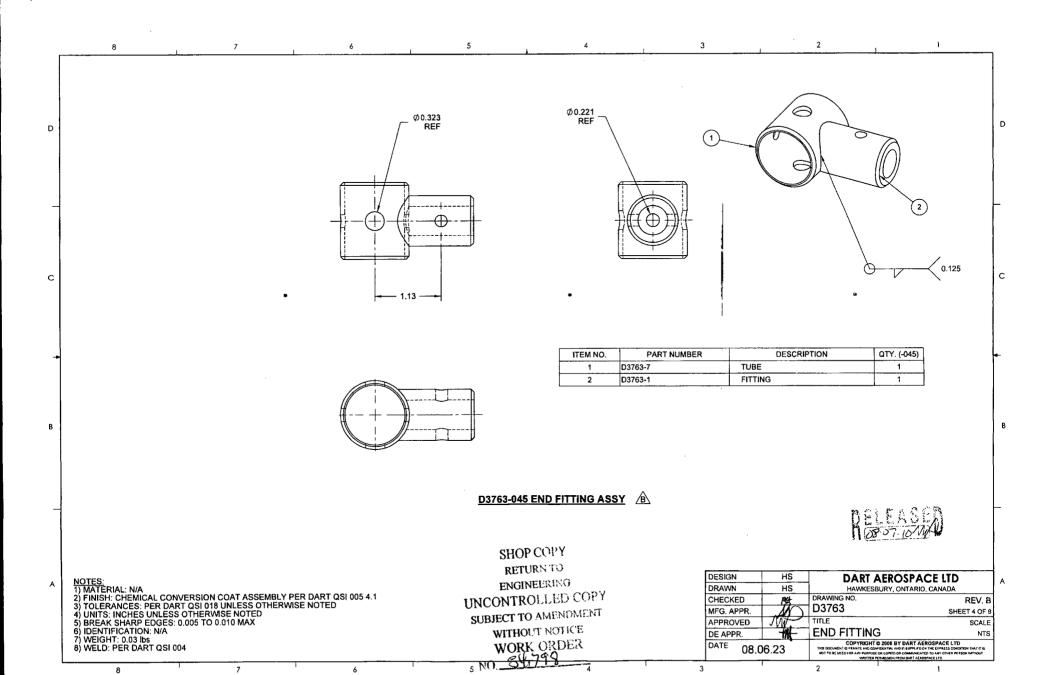
NOTES: 1) MATERIAL: N/A 2) FINISH: CHEMICAL CONVE 3) TOLERANCES: PER DART 4) UNITS: INCHES UNLESS O 5) BREAK SHARP EDGES: 0.0 6) IDENTIFICATION: N/A 7) WEIGHT: 0.03 lbs 8) WELD: PER DART QSI 004	QSI 018 UNLESS OTHERW THERWISE NOTED	PER DART QSI 005 4.1 ISE NOTED		SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER
8	7	6	5	NO 54768

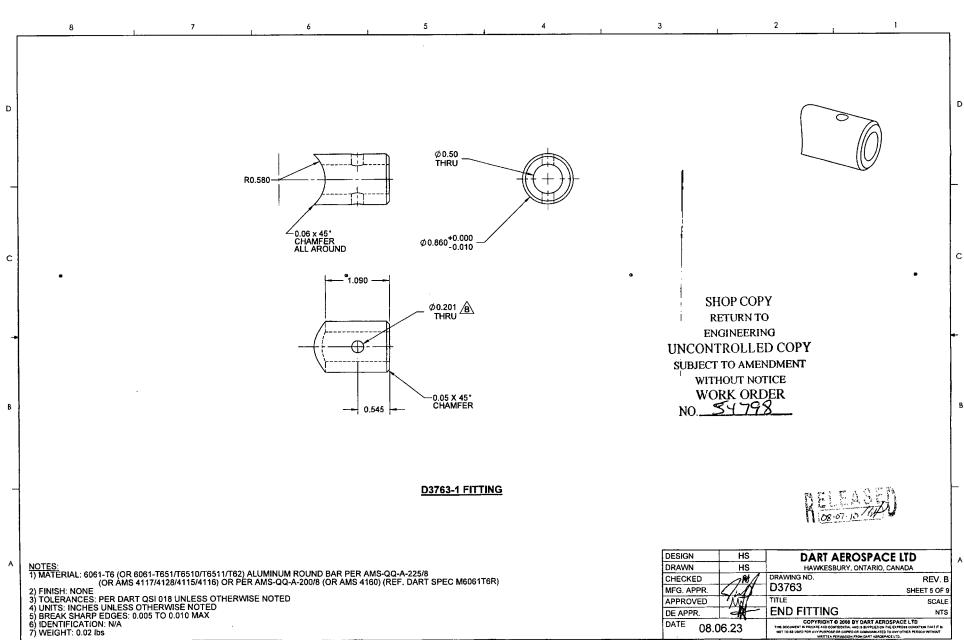
CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY Α NEW ISSUE REV. DESCRIPTION DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED D3763 MFG. APPR. APPROVED **END FITTING** DE APPR. DATE 08.06.23

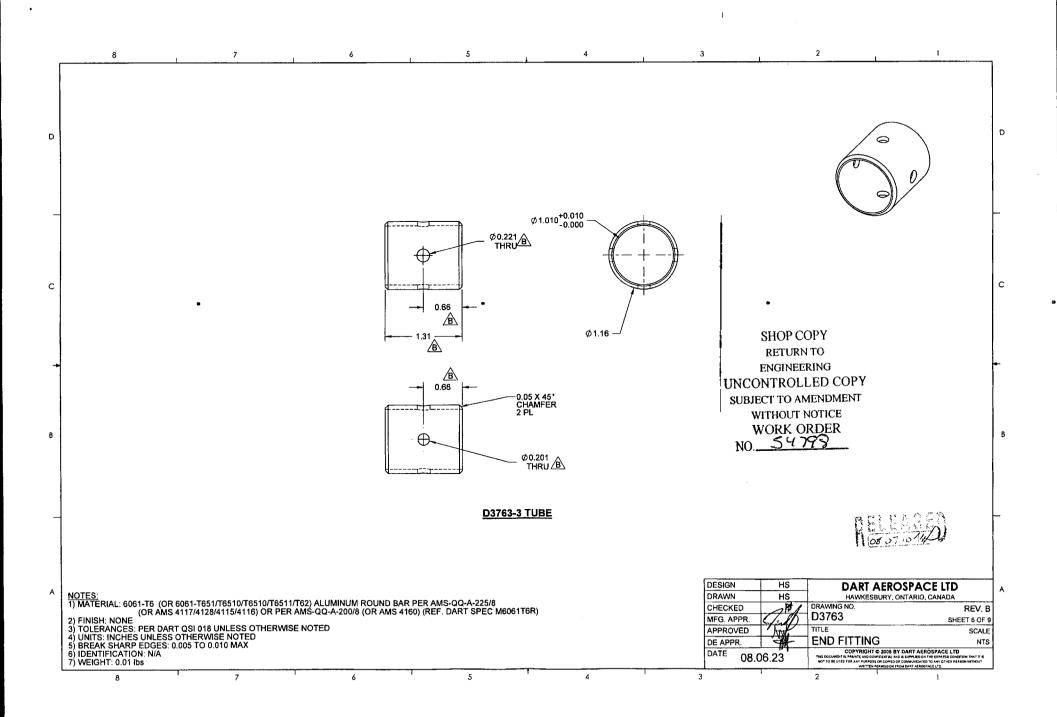
CLG/12/23

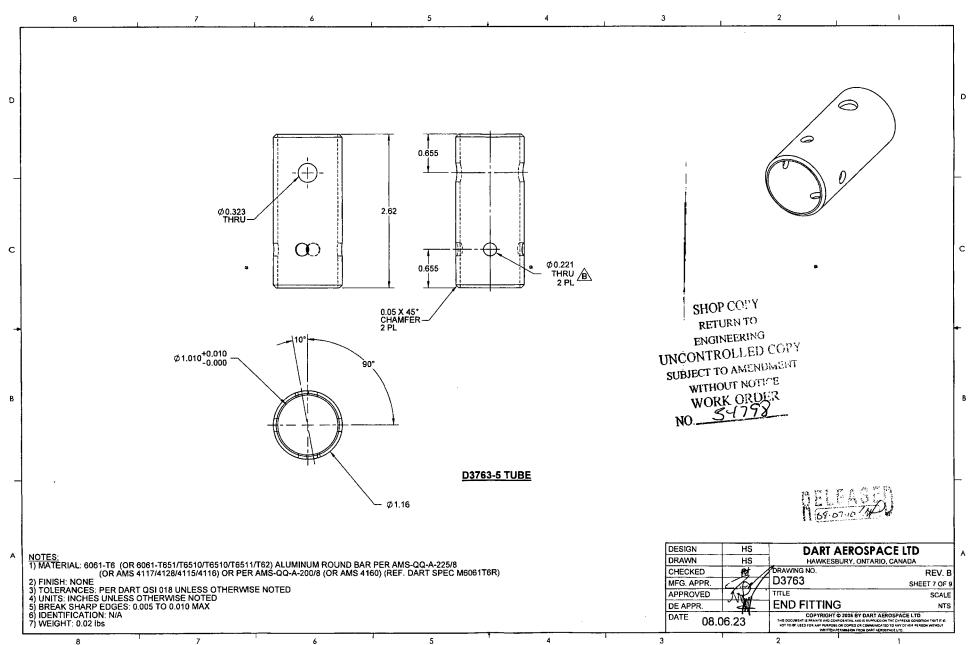


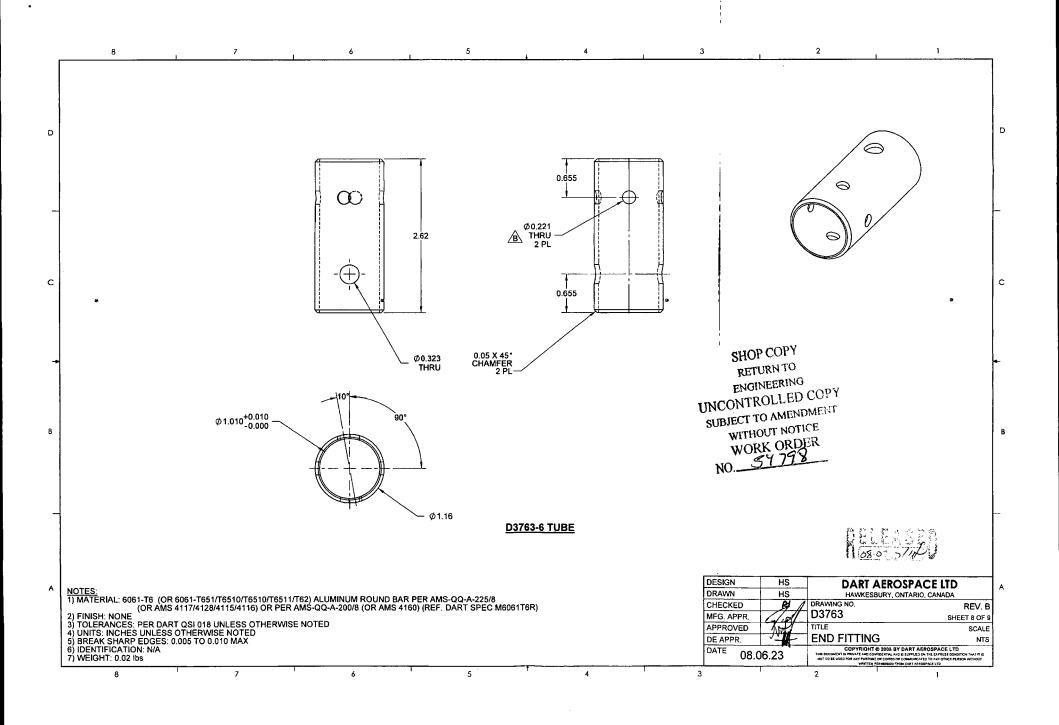












Ø1.010^{+0.010}_{-0.000} Ø0.221 THRU С 0.66 Ø1.16 SHOP COPY 1.31 RETURN TO ENGINEERING UNCONTROLLED CCPY SUBJECT TO AMENDMENT -0.05 X 45° CHAMFER 2 PL 0.66 without notice WORK ORDER NO. 51798 Ø0.323 THRU D3763-7 TUBE A DESIGN HS DART AEROSPACE LTD NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R) DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX D3763 MFG. APPR. SHEET 9 OF 9 TITLE APPROVED SCALE

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DE APPR.

DATE

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END FITTING

08.06.23

6) IDENTIFICATION: N/A 7) WEIGHT: 0.01 lbs